

Date: Tuesday, 4/17/2007 3:56:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER DECKPLATE 350
Job Number	: 31918		
Estimate Number	: 10357		
P.O. Number	: <i>N/A</i>	Part Number	: D2344
This Issue	: 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2344 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 29143	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 5/2/2007 Qty: 10 Um: Each
Checked & Approved By	: <i>07.04.18</i>		
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 7.8225 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch *M101022 (8)* *M102942 (4)* *SAD 07/05/18* *10*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

SAD 07/05/18 *(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/18 *(10)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2005-23 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB

1-Deburr sharp edges

2-Countersink holes per Dwg D2344

m107/05/18

(P10)
X10

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2005-28 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/15/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070528	5.0	Up parts scrap. C'sink is way too deep, due to C'sink dimension on the dwg.	<u>Q51042</u>	destroy scrap parts. See PAR for C'sink size change. PAR 181	<u>07/05/28</u>	<u>070528</u>	<u>Q51042</u>	<u>070528</u>

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER DECKPLATE 350

Job Number: 31918

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HSJ 07-05-29 (6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m 1023/6 *bl/a.m* 07/05/30 (6)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/5/31 (6) *59*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: *SF222*

7/5/31 *50/6* (6)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/5/31 (6)

Job Completion



U 07-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31918
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005					
6.223	+/-0.010	6.228	✓		Vern	
5.598	+/-0.010	5.593	✓		Vern	
4.869	+/-0.010	4.872	✓		Vern	
3.889	+/-0.010	3.891	✓		Vern	
3.096	+/-0.010	3.100	✓		Vern	
2.891	+/-0.010	2.891	✓		Vern	
N/A 16.973	+/-0.010	N/A				CE
N/A 0.966	+/-0.005	N/A				CE
0.450	+/-0.010	0.450	✓		Vern	
4.423	+/-0.010	4.422	✓		Vern	
4.723	+/-0.010	4.720	✓		Vern	
1.202	+/-0.010	1.202	✓		Vern	
5.869	+/-0.010	5.869			Vern	
4.654	+/-0.010	4.653	✓		Vern	
Ø0.656	+0.005/-0.000	Ø0.656	✓		Vern	
1.888	+/-0.010	1.890	✓		Vern	
2.285	+/-0.010	2.290	✓		Vern	
2.683	+/-0.010	2.690	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.173	✓		Vern	
0.750	+/-0.005					CE
3.491	+/-0.010	3.495	✓		Vern	
Ø0.191	+0.005/-0.000	Ø0.192	✓		Vern	
N/A 0.796	+/-0.005					CE
N/A 3.128	+/-0.010					CE
1.527	+/-0.010					CE
1.975	+/-0.010	1.980	✓		Vern	
E Ø0.128	+0.005/-0.000	Ø0.131			Vern	CE
Measured by: SAD	Audited by: [Signature]		Prototype Approval:		N/A	
Date: 07/05/18	Date: 07-05-23		Date:		N/A	

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	[Signature]

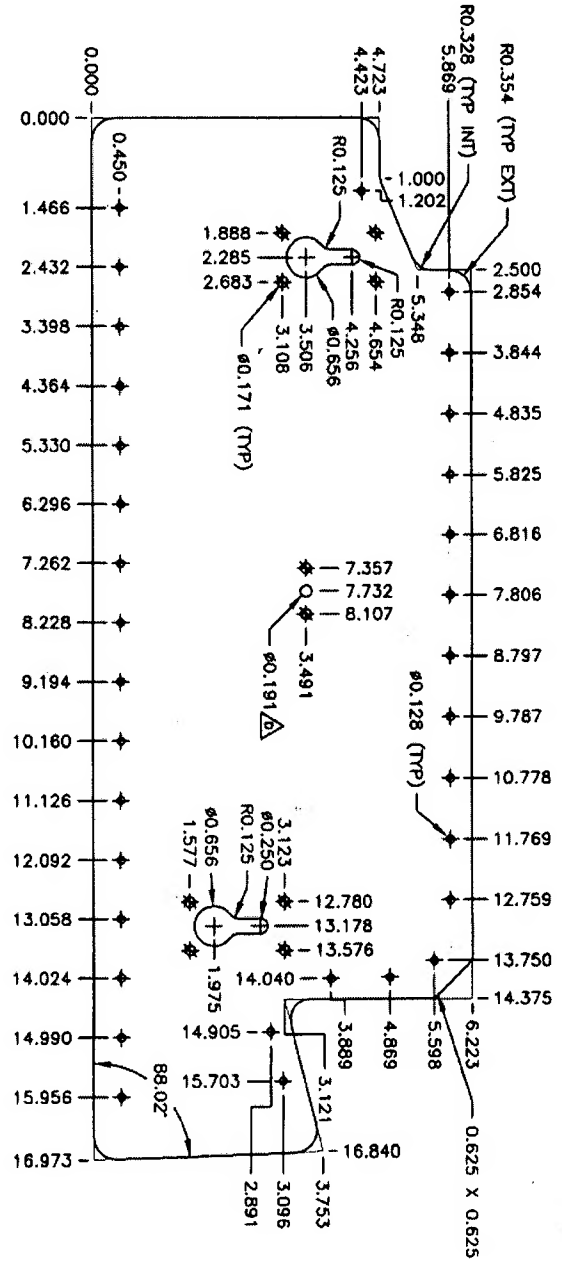
COUNTER SINK HOLES:
 * C/SINK Ø0.225 X 100°
 * C/SINK Ø0.300 X 100°

Ø0.285 X 100° 107.05.28

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NO. 21918
 WORK ORDER
 WITHOUT NOTICE
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 RETURN TO
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MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED



DART

DESIGN	KE	CHECKED	DATE	98.06.19	NEW ISSUE	95.01.14	A
DRAWN BY	KE	APPROVED	DRAWING NO.	D2344	MOVED KEY HOLES	95.02.09	B
			REV. E	SHEET 1 OF 1	LITTER DECK PLATE, 350	95.03.06	D
			SCALE	1:3	0.063-0.071 THICK WAS 0.071 (TSR A371)	98.06.19	E

DART Aerospace Ltd
 HAWKESBURY, ONTARIO, CANADA